

Date: Friday, 9/21/2007 1:01:24 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	FLOAT WEB	
Job Number	34794		Part Number	D3282041	
Estimate Number	10791		Drawing Number	D3282 REV C	
P.O. Number	N/A		Project Number	N/A	
This Issue	9/21/2007		Drawing Revision	C	
Prsht Rev.	NC		Material	N/A	
First Issue	N/A		Due Date	10/5/2007	
Previous Run	33878		Qty:	12	Um: Each
Written By			Handwritten signature: 07/09/24		
Checked & Approved By					
Comment	Est Rev B 05.09.23 Procedure change KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2792130	EXTRUSION
-----	----------	-----------



Comment: Qty: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2792-130	Extrusion	833518

AWM
07/09/25

Identify as D3282-1

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

Cut to length as per Dwg D3282.

AWM
07/09/25

(1)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



(Prod)

Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA579 & Dwg D3282

2-Deburr

JF/JL/SD 07/10/16

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



JF/JL/SD 07/10/16

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



JF/JL/SD 07/10/16

Comment: SECOND CHECK

JF/JL/SD 07/10/16

(12)

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/15	B	1 web is scrapped, operator forgot to raise "Z" after installing parallels, end-mill machined bottom of web R/C: Human error	Initial 07/10/30	SCRAP + REPLACE Replace.	JL 07/10/15	✓ 07/10/16	✓ 07/10/30	✓ 07/10/15
07/10/15	C	one web has three holes so out of spec while drilling. R/C: Drill hit the scrapit	CP 07/10/17 per QS10472	Part are acceptable Enlarged holes will have no noticeable effect on strength of web. ON NEUTRAL AXIS	✓ 07/10/16	✓ 07/10/17 per QS10472	✓ 07/10/17 per QS10472	✓ 07/10/16
		Block						

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: FLOAT WEB
Job Number: 34794		Part Number: D3282041
Job Number: 		
Seq. #:	Machine Or Operation:	Description:
6.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 A/W/M 07-10-18 
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005.4.1		
7.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION D/P 7-10-18 (12)
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
8.0	D32831 	Doubler 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)		
Pick: Qty Part Number Description Batch 2 D3283-1 Doubler B 3482a 24 7-10-18		
9.0	MS20470AD47 	Rivet, Universal Head 
Comment: Qty.: 57.0000 Each(s)/Unit Total : 684.0000 Each(s)		
Pick: Qty Part Number Description Batch 57 MS20470AD4-7 Rivet M104936 7-10-18 (12) (12)		
10.0	LANDING GEAR 1 	LANDING GEAR RESOURCE 1 
Comment: LANDING GEAR RESOURCE 1		
1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web A/R/N/ALPS-3 M10492a 7-10-18 (12) (12)		
11.0	QC5 	INSPECT WORK TO CURRENT STEP E 03/10/19 (12) (12)
Comment: INSPECT WORK TO CURRENT STEP		
12.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: LG		7-10-22 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:01:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 34794

Part Number: D3282041

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 9/18/07

W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

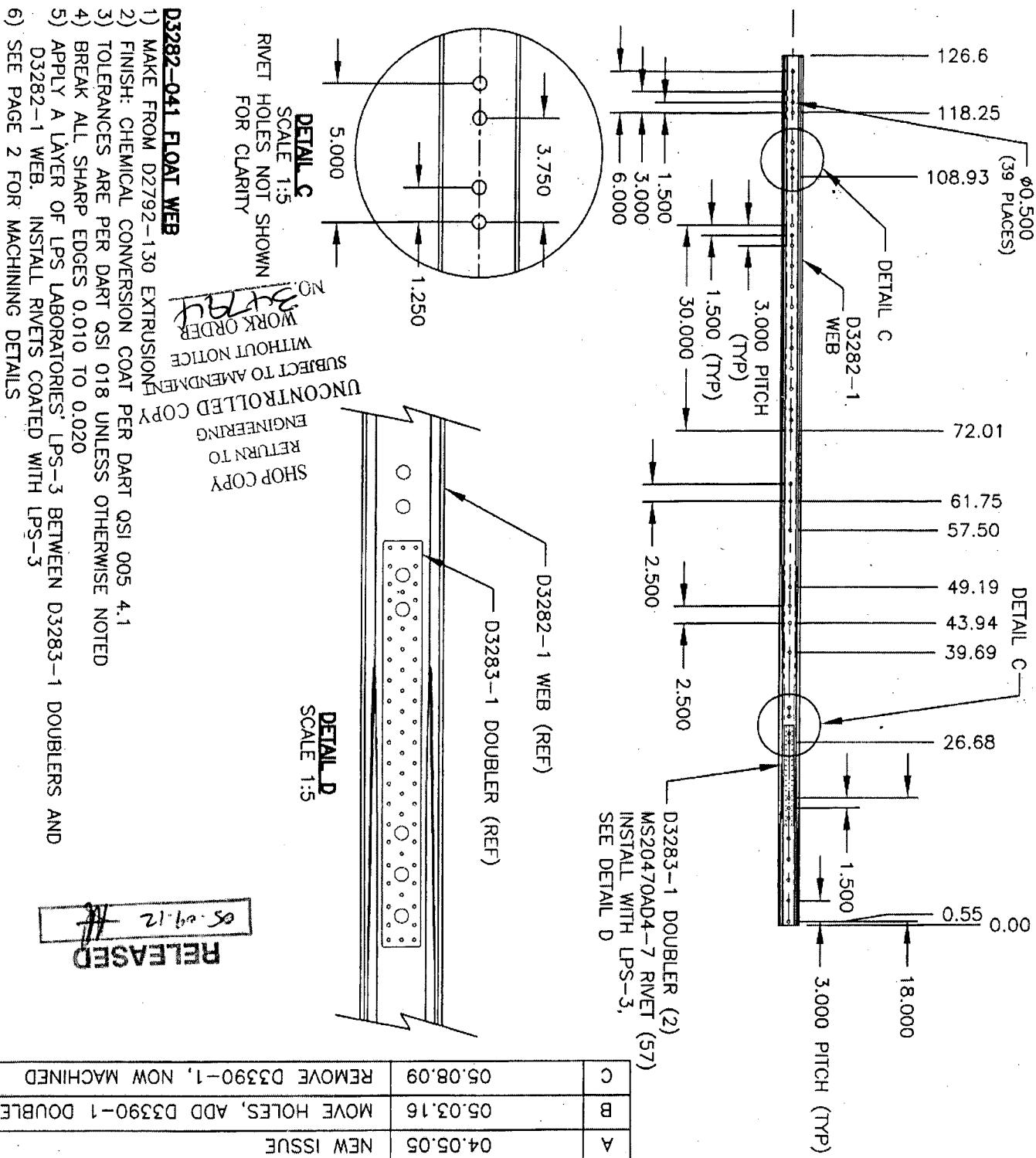
DART AEROSPACE LTD	Work Order:	34794
Description: Float Web	Part Number:	D3282-041
Inspection Dwg: D3282	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.L.	Audited by:		Prototype Approval:	N/A
Date:	07/10/13	Date:	07. 10. 13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	<i>[Signatures]</i>



PORT HADLOCK, WA

DART AEROSPACE USA, INC.

DART



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CP	CP	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
#	#	D3282
DATE		REV. C
05.08.09		SHEET 2 OF 2
		SCALE
		1:20

SECTION A-A

R0.250
(TYP)

D3283-1
DOUBLER
(REF)

0.05
(TYP)

2.38

D3282-1 MACHINING NOTES

1 UNIFORM SECTION A-A

2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B

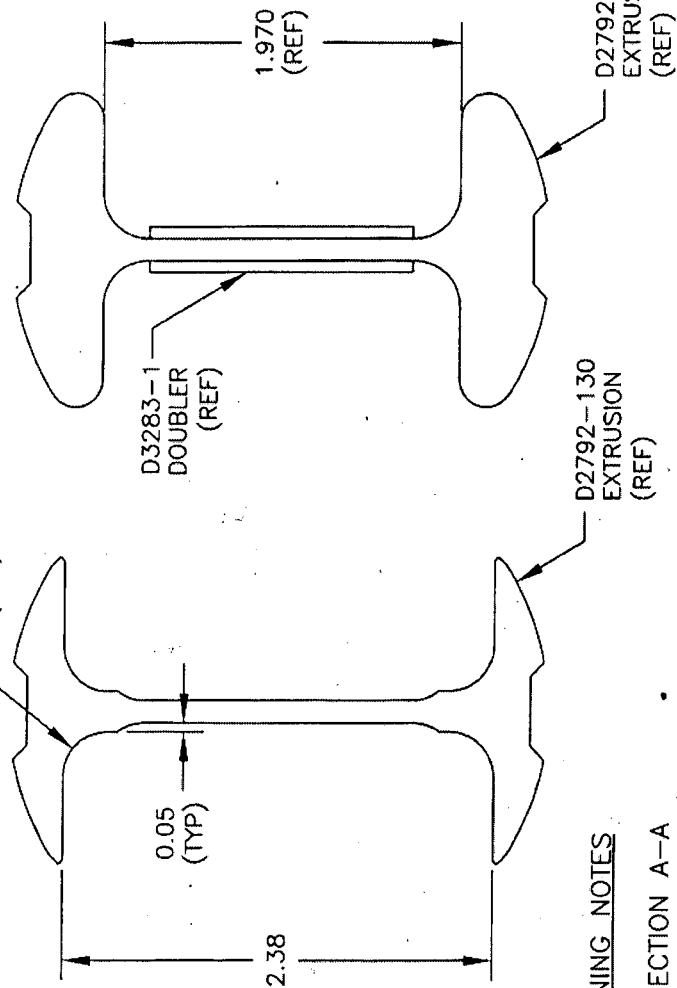
3 UNIFORM SECTION B-B

UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
DRILL #30 (.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1,
SEE DETAIL D FOR REFERENCE

4 UNIFORM SECTION A-A

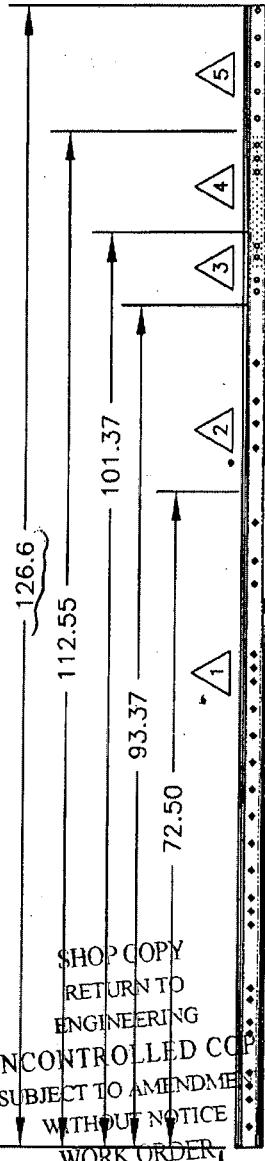
5 R1.00 BETWEEN SECTIONS

6
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34794



RELEASED

05-09-12



Copyright © 2004 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

